

S193613



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6201

Job Sheet 195526



Part No: D6201

Job Qty: 24 ft

MAY 28 2019

Part Name: T Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/24/19

Job Tracking No:

Due Date: 6/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	24 ft	20	6/21/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	24 pcs		6/21/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6 - 18 vm	24 pcs	6/21/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
130	Packaging 3-1 - Stock - B4B	24 pcs	6/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA FT	24 ft	6/21/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUN 2 8 2019
					QC 21 - SA - 53	DAS 70 9-89

Part Op 100 - Issue P/O: _____ a)Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile
 Descriptions: Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached

120 - (QC6- All purchased or subcontracted products) Ensure Material certification comply to Dwg D6201

130 - (Identify as per dwg & Stock Location: _____ LOCATION: MAT028

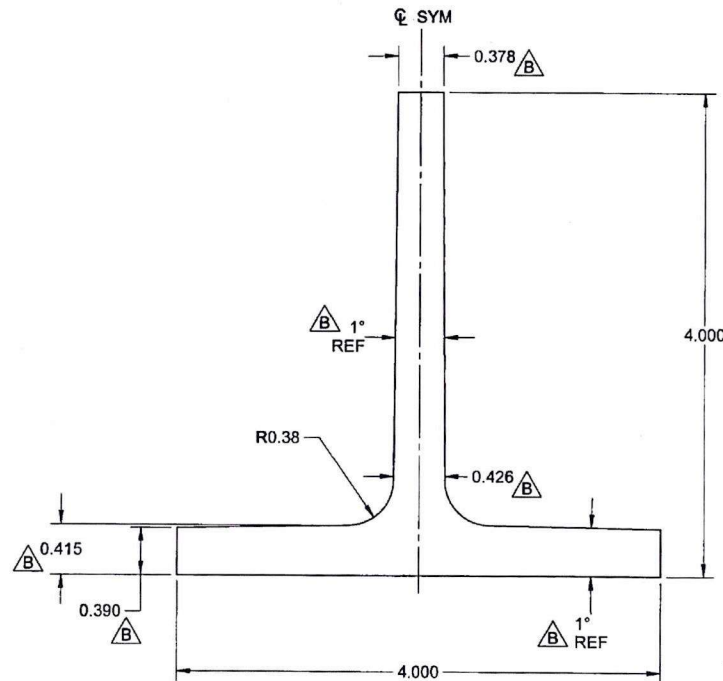
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6201P	T Extrusion 4X4X3/8	24 ft (1 ea)	100-Purchasing - Ft	5198606
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6201P	24	0	0
Part Specifications				
Specifications could not be found.				

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SPECIFICATION CONTROL DRAWING

Line 1
D6201

DAS
31
9-89



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES
EG. 27 INCHES LONG EXTRUSION: D6201-027

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195526 ML5
1905-24

NOTES:

- 1) MATERIAL: ALUMINUM T-EXTRUSION, ROUND FILLET
6061-T6/T6511 PER AMS-QQ-A-200/8 OR QQ-A-200/8 OR ASTM B221
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.67 lb/ft

RELEASED
2017-07-27
EGN 17-660

B	REFORMAT TO CURRENT STANDARDS; 1" TAPERS DEFINED BY 0.378 & 0.426 AND 0.390 & 0.415 WERE NON-TAPERS (0.375). REASON: CAR17-164. UPDATE MATERIAL CALLOUT.	ML	17.06.05
A	NEW ISSUE	CP	01.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	LL		
APPROVED	WM		
DE APPR.	CP		
DATE	17.06.05		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D6201**
REV. B
SHEET 1 OF 1
SCALE
NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043557



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043557

PO Date: 5/28/19

Due Date: 6/12/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

EMAILED
MAY 30 2019

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195526	D6201P		T Extrusion 4X4X3/8 AS PER DWG D6201 REV. A	Firmed	-	6/27/19	20 ft	0 ft	20 ft	\$23.0135/ft	\$460.27
2	195789	D6201P		T Extrusion 4X4X3/8 AS PER DWG D6201 REV. A	Firmed	-	6/12/19	11 ft	0 ft	11 ft	\$22.00/ft	\$242.00
Grand Total:												\$702.27

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CZ

Plex 5/30/19 1:09 PM dart.lavoie.chantal

**ACIER OUELLETTE INC.**

935, Boul. du H vre
Salaberry de Valleyfield (Qu bec) J6S 5L1
T l.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT**Copy**

CO0015022

Billed to
DART AEROSPACE LTD
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att :

Delivery Route 5

Customer N  CLI0001056
Date 2019/05/30
Delivery date **2019/07/25**
Your order N  POHB043557
Processed by Josianne Bourdon
Salesman JOSIANNE BOURDON
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days

Instruction F-M

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 T-BAR ALU 4 X 4 X 3/8 * TBAL-4438 6434 1 X 20' PO HB043557 LINE 1 Heat : 5534309 AC26567-GR-20/06	68.60	20.00	PI_\$CLB		14 20'						
		1.00	UN_\$UN								
Note : ATTENTION: MILL TEST REQUIS Chaque item identifier avec : - Le # PO client - Le # d'item - Le heat # - Emballer les pi�ces dans carton											

Conditions :

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Total Weight (Lbs) : 68.60

NIR : R-109516-6

Prepared By : ce	Verified By :	Delivered By : SR	Time 11:04	Y 	M 	D
Customer's Signature				Date		

ISO 225

DAR1

26567N



SIGNATURE ALUMINUM CANADA
1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No.	Sales Order	Page
06/08/2019	5534309	136412	1
Cust PO	B/L No	Lot	Date
B 87015835	043179	920846	06/08/19

Item No	Part No	Item Description	Cust Part
001	C-031522-6	240" MILL 6061 T6	26934 4X4X.375 T
Gross Weight	1,325 LBS		
Net Qty	1,299 LBS	19 PCS	2 PKGS
Specification	ASTM B308-02 & ASTM B221-08		

Mechanical Tests:

Tensile	Yield		
MPA / KSI	MPA / KSI	% Elongation	HRE
277.3 / 40.2	253.8 / 36.8	15.3	92
		Conductivity	
		N/A	

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Pb	V	Zr
0.59	0.27	0.21	0.05	0.92	0.07	0.08	0.02	0.01	0.00

Signature

4" X 4" X 3/8"

Alum T6

June 2019

This Material is Made in Canada
This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealuminum.com

Rev A

Heat: 5534309

4" X 4" X 1/8"

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6201

PO / BATCH NO.: POH8043557/

DATE: JUN 25 2019

5193606

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 3/8"

QUANTITY RECEIVED: 20 Ft

THICKNESS RECEIVED: 3/8"

QUANTITY INSPECTED: 20 Ft

SHEET SIZE ORDERED: -

QUANTITY REJECTED: -

SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	<u>ASTM B221</u>
CORRECT MATERIAL PER M-DRAWING	☒ Y N	
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>HT: 5534309.</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____	DAS 81 9-89	SIGNED OFF BY: _____
DATE: <u>JUN 25 2019</u>		DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in